

Work Order ID 138737

138737

Page 1

Wednesday, November 11, 2015 7:18:22 AM

Item ID: D3391-025 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Tube Assembly
 Start Date: 11/11/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 11/11/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: NOV 11 2015 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3391	I								

100 0.00
100 MORI SEIKI CNC LATHE LARGE
 Mori Seiki Memo 0.02
 Mori Seiki CNC Lathe Large Turn as per Folio FA599 Rev: AA & Dwg D3391 Rev: I
 ensure steady rest is turning true
 ****REMOVE STEADY REST AND MACHINIG MARKS****

L φ
 9mm L
 15/11/24

110 0.00
110 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00
 Quality Control

1 φ
 9mm L
 15/11/25

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition																					
								Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐																			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :			
Misidentified	☐	Past Due	☐				

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Item ID: D3391-025

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Tube Assembly

Start Date: 11/11/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/11/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

QC8- Inspect parts - second check

0.00

140

QC

Memo

0.00

Quality Control

INSPECT INSIDE BORE

1 0 15/12/07

150

Skidtubes

0.00

150

Skidtubes

Memo

0.00

Skidtubes

1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

15-12-7

160

BENDING MACHINE - SKIDTUBES

0.00

160

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

Form as per Dwg D3391 Using Bend Prog 3391025

15-12-7

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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OTHER : _____																																																															

Work Order ID 138737***138737***

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Item ID: D3391-025

Accept

N1900040100Setup Start ***NS1***

Revision ID:

Item Name: Aft Tube Assembly

Stop ***NS2***

Start Date: 11/11/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/11/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp**DAS**
18
9-89

170

QC5- Inspect part completeness to step on W/O

0.00

4.25

170

QC

Memo

0.00

Quality Control

1 0 1512-07

Work Order ID 138737

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Item ID: D3391-025 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Tube Assembly
Start Date: 11/11/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 11/11/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Skidtubes	0.00							
180									
Skidtubes	Memo	0.02							
	1-Open Aft cap pilot hole to .208" as per Dwg D3391								
	2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.								
	3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig . *****Do Not Open To Finished Size*****								
	4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes.								
	5-Open wearplate holes to 0.297" and c'bore as per dwg D3391								
	6-Open up all float bag holes to 0.328" and c'sink as per Dwg D3391.								
	7-Deburr								
	8- Scribe batch # on fwd end								

15-12-812

Work Order ID 138737

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Item ID: D3391-025 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Tube Assembly
 Start Date: 11/11/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 11/11/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC5- Inspect part completeness to step on W/O	0.00							
190									DAS
QC	Memo	0.00							38
Quality Control									9-89
									DEC 09 2015
200	Chemical Conversion Coat per QSI005 4.1	0.00							
200									
HandFinish	Memo	0.01							
Hand Finishing									
210	QC7-Inspect Chemical Conversion Coat	0.00							
210									
QC	Memo	0.00							
Quality Control									

1 15-12-10

15-12-10

Work Order ID 138737

Wednesday, November 11, 2015 7:18:22 AM

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Page 7

Item ID: D3391-025 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Tube Assembly
 Start Date: 11/11/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 11/11/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220		0.00							
220	Skidtubes	0.01							
Skidtubes	Memo 1- Instal spacers as per dwg D3391 A/R Magnabond 6398 Batch: <u>131589</u> exp. date : <u>16-2-30</u> cure time 12hrs as per QSI0015								
Skidtubes	2- Grind crossbolts flush								
	3- Back drill using #9 drill								
	4- Touchup Magnabond								
	5- Deburr								
230	QC5- Inspect part completeness to step on W/O	0.00							
230									
QC	Memo	0.00							
Quality Control									

DAS
9
9-89

15-12-10

15-12-22

[Handwritten signature] 15-12-10

15-12-22

DAS
9
9-89

Work Order ID 138737

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Item ID: D3391-025 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Tube Assembly
Start Date: 11/11/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 11/11/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
235	Pressure Wash per QSI005 4.3	0.00							
235									
HandFinish	Memo	0.01							
Hand Finishing	AND REALODINE AS PER PAR09-043								
240	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
240	<i>m 133714.</i>								
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <i>2:20</i> OVEN TEMPERATURE: <i>320</i> FINISH TIME: <i>2:50</i>								
250	QC3- Inspect Part Finish	0.00							
250									
QC	Memo	0.00							
Quality Control									

DAS
15
9-89

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138737

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Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Aft Tube Assembly

Stop *NS2*

Start Date: 11/11/2015 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 11/11/2015 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run	Start	*NR1*
	Stop	*NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

260

0.00

260

HandFinishing

0.01

HandFinish

Memo

Hand Finishing

1-Install inserts as per Dwg D3391
2-Install Aft Cap as per Dwg D3391
A/R Sikaflex-241/-291 1/133427
Sikaflex expiry date: 16107

3- INSTALL WEARPLATES AS PER DWG

270

QC5- Inspect part completeness to step on W/O	0.00
---	------

0.00

270

OC

Memo

0.00

Quality Control

DAS
38
2.80

JAN 13 2016

280

Identify as per dwg & Stock Location: W/O

0.00 10412-742-043 / 13137594

280

Packaging

Memo

0.01

Packaging

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Item ID: D3391-025

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Aft Tube Assembly

Stop ***NS2***Start Date: 11/11/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 11/11/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
290	QC21- Final Inspection - Work Order Release	0.00							
290 QC	Memo	0.00							
Quality Control									

ML5 JAN 14 2016ML5 JAN 14 2016

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Page 1

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D3391-025

Required Date: 11/11/2015

Required Qty: 1.00

Comments:	IPP Rev B	06-02-07	ECN773 dwg rev. D	EC	
	IPP Rev:C	06-03-28	Update Manuf. Instructions	JLM	
	IPP rev D	07.03.20	revF dwg	EC	
	IPP rev E	07.11.07	rev G dwg ecn 1053p	EC	verified by: DD
	IPP Rev:F	07-11-13	ECN 1056	DD	verified by: EC
	IPP Rev:G	08-09-10	revH as per dwg	DD	verified by:EC
	11.11.14 AS PER REV.I	DD	verified by:JLM		IPP Rev:H

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4095-047		Manufactured	No			260	Each	8.0000	1	1			
D4095-047													
Wearpad Aft													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				FP001			8						
					116100		2						
					<u>136693</u>		6						
D4095-049		Manufactured	No			260	Each	20.0000	1	1			
D4095-049													
Wearpad Aft													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				FP001			20						
					<u>126331</u>		20						
D6014-090		Manufactured	No			100	Each	49.0000	1	1			
D6014-090													
ALUMINUM EXTRUSION													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				LG003			49						
					134851		30						
					<u>86063</u>		19						

Picklist Print

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Work Order ID: 138737

138737

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 11/11/2015

Required Date: 11/11/2015

Start Qty: 1.00

Required Qty: 1.00

D3670-4-200

Manufactured No

230

Each

31.0000

4

D3670-4-200

Bushing

**

DP 15-12-10

Location

Loc Qty

Loc Code

FG

87709

10

10

LG002

21

132777

6

134974

15

4

D2646

Manufactured No

270

Each

72.0000

1

1

D2646

Aft Cap

**

11 16/01/08

Location

Loc Qty

Loc Code

FG

4

85848

2

90495

2

FP001

68

103306

1

127924

1

132325

10

132326

6

136885

50

XL

Picklist Print

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Work Order ID: 138737

138737

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 11/11/2015

Required Date: 11/11/2015

Start Qty: 1.00

Required Qty: 1.00

D3672-1

Manufactured No

270

Each

766.0000

2

2

D3672-1

Washer, Phenolic

ll 16/01/11

Location

Loc Qty

Loc Code

FG

10

85222

10

FP001

18

113581

18

ST049

235

112218

72

127322

163

ST051A

500

134785

500

ST055

3

120116

3

ALS4-1032-130

AELS4-1032-130 Purchased

No

260

Each

3,054.000

14

14

AI S4-1032-130

Rivnut

ll 16/01/11

Location

Loc Qty

Loc Code

CCK004

3054

M133077

3054

ALS4-1032-225

AELS8-1032-225 Purchased

No

270

Each

510.0000

8

8

AI S4-1032-225

Rivnut

ll 16/01/11

Location

Loc Qty

Loc Code

FG

120

M127028

120

FP001

33

M131582

33

st549

357

M131582

357

M133772

x 8

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Shop Packet Print

Page 3

Picklist Print

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Work Order ID: 138737

138737

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 11/11/2015

Required Date: 11/11/2015

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

270

Each

777.0000

6

6

AN3C4A

Bolt

Handwritten: 11/16/01/11

Location

Loc Qty

Loc Code

FG	20	
122814	20	
FP001	377	
M131420	12	
M132317	76	
M132551	61	
M132803	50	
M133440	178	
ST349	12	
M133234	12	
ST350	368	
M133440	368	

Handwritten: x6

AN3C5A

Purchased

No

270

Each

402.0000

4

4

AN3C5A

Bolt

Handwritten: 11/16/01/11

Location

Loc Qty

Loc Code

FG	5	
122800	5	
ST338a	147	
M131803	8	
M132640	64	
M133483	75	
ST350	250	
M133234	250	

Handwritten: M133769

Handwritten: x4

Picklist Print

Wednesday, November 11, 2015 7:18:26 AM

Page 5

Work Order ID: 138737

138737

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 11/11/2015

Required Date: 11/11/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

270

Each

4,114.000

10

10

NAS1149C0332R

WASHER

Location

Loc Qty

Loc Code

FP001

1004

m132930

1004

FP01

581

m133284

581

GA

435

m133284

435

ST271

2094

m133284

2094

20 10/10/15
x10

DART AEROSPACE LTD		Work Order: 138737
Description: Float Skidtube (412)		Part Number: D3391-3
Inspection Dwg: D3391	Rev: I	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

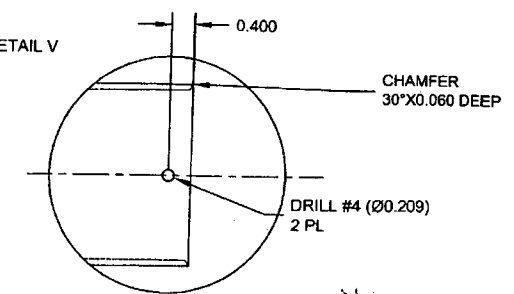
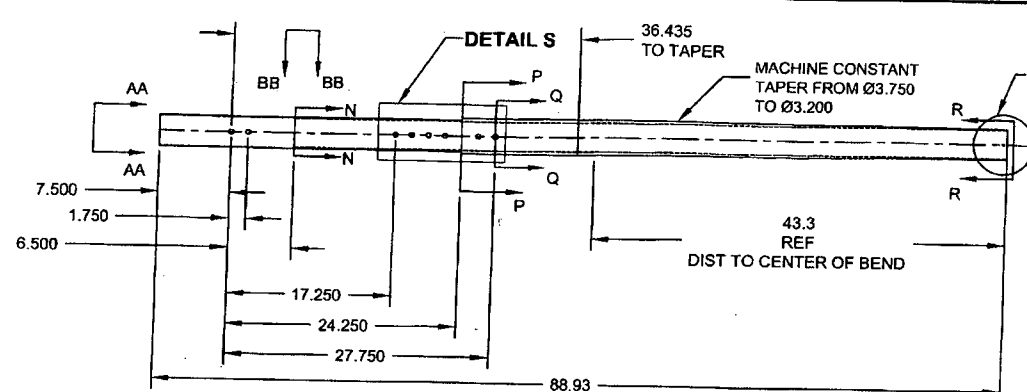
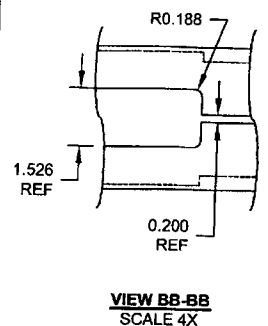
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.000	✓		tape	L6-11
3.500	+/-0.010	3.504	✓		vein	CNC-08
Ø3.200	+/-0.010	3.202	✓		↓	
Ø3.750	+/-0.010	3.750	✓			
30° x 0.060 chamfer	+/-0.010	30° x .060	✓			
88.93	+/-0.030	88.93	✓		tape	L6-11

Measured by: <i>mm</i>	Date: 15/11/24
Audited by: <i>mm</i>	Date: 15/12/07

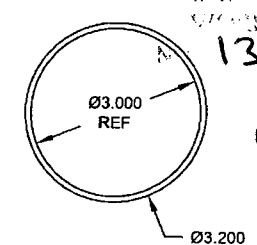
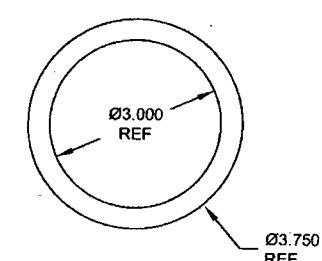
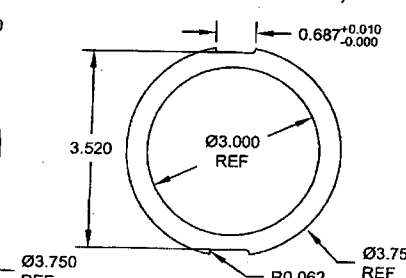
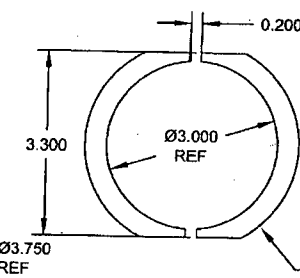
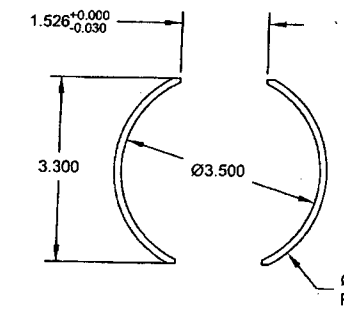
HAAS Section						
1.526	+0.000/-0.030	1.515	✓		SL10	Vein
7.500	+/-0.010	7.500	✓		SL01	Tape
27.750	+/-0.010	27.750	✓		↓	
31.750	+/-0.010	31.750	✓			
35.250	+/-0.010	35.250	✓			
3.300	+/-0.010	3.298	✓		SL10	Vein
0.200	+/-0.010	.199	✓		↓	
3.520	+/-0.010	3.521	✓			
0.687	+0.010/-0.000	.690	✓			
R0.062	+/-0.010	.062	✓			
Ø0.484	+0.005/-0.001	DAS .486	✓			

Measured by: 20 9-89	Date: 15-12-03
Audited by: <i>mm</i>	Date: 15/12/07

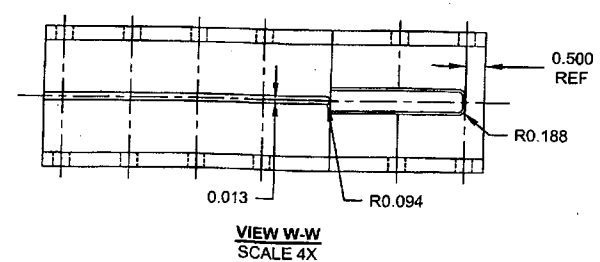
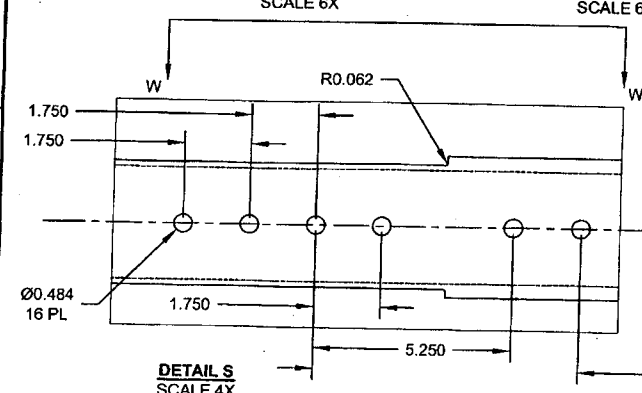
Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	
H	11.06.21	Dimension 44.995 removed	KJ	
I	12.05.15	Dwg Rev updated	KJ	
J	12.05.23	Dimension updated	KJ	
K	12.10.15	88.93 dimension removed	KJ	
L	12.11.28	88.93 dimension added	KJ	<i>mm</i>



D3391-3 AFT DRILLING AND CUTTING DETAIL
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)



UNCONTROLLED
SUBSTITUTION
WITH
138737
ML5
157111



RELEASED
2011-11-04

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO.	REV. 1
MFG. APPR.		D3391	SHEET 7 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	11.10.13	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. ANY REPRODUCTION OR DISSEMINATION OF THIS DOCUMENT IS PROHIBITED WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

